



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4016-1
Job Sheet 167920



Part No: D4016-1

Job Qty: 3 ea

Part Name: Hinge Half, Base



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/8/17

Job Tracking No:

Due Date: 11/9/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea	11/8/17	11/8/17	0.00	0.00	Start Up Machining	FM	FM
100	Bandsaw	3 pcs	11/8/17	11/8/17	0.00	0.19	Bandsaw1	FM	FM
110	CNC Vertical Machining	3 pcs	11/9/17	11/9/17	0.03	1.29	HAAS 1		FM
130	QC	3 pcs	11/9/17	11/9/17	0.00	0.00	QC8	JAS	
160	Packaging	3 pcs	11/9/17	11/9/17	0.00	0.00	Packaging3	6	
170	QC21-SA	3 Ea	11/9/17	11/9/17	0.00	0.00	QC21	30	

Part Op 100 - CUT BLANK 1.00" LONG

Descriptions: 110 - MACHINE AS PER FOLIO FA869 AND DWG

160 - LOCATION: WA004

WROU

DAS
21
9-89

NOV 15 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304B1.000X1.000	0	34	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hinge Half, Base	0.875Inches $\pm$ 0.010	0.885 0.865		
2	Hinge Half, Base	0.250Inches $\pm$ 0.030	0.280 0.220		
3	Hinge Half, Base	0.380Inches + 0.030 - 0.000	0.410 0.380		
4	Hinge Half, Base	0.030Inches $\pm$ 0.030	0.060 0.000	Radius	
5	Hinge Half, Base	0.130Inches $\pm$ 0.030	0.160 0.100		
6	Hinge Half, Base	0.880Inches $\pm$ 0.030	0.910 0.850		
7	Hinge Half, Base	0.257Inches + 0.006 - 0.001	0.263 0.256	Diameter	
8	Hinge Half, Base	0.380Inches $\pm$ 0.030	0.410 0.350	Radius	
9	Hinge Half, Base	0.500Inches $\pm$ 0.030	0.530 0.470		
10	Hinge Half, Base	0.750Inches $\pm$ 0.030	0.780		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			

DART
AEROSPACE
S009121

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Hinge Half, Base

PART NO: D4016-1
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 11/13/17

Job No: 167920